

5/44

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24497
<b>Description:</b> 206 Extrusion Bending	<b>Part Number:</b>	D2620
<b>Drawing:</b> D2620 Rev. B	<b>Qty:</b>	<del>30</del> 36

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.10.12	30
2	LG	Bend D2600-1 extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio F008 Batch <del>P20534</del>	DP	05-11-21	36
3	LG	Cut Fwd end of tube as per Dwg D2620	DP	05-11-21	36
4	QC5	Inspect for Completeness on the W/O	BE	05-11-21	36
5	LG	Identify and Stock in LG Cell	DP	05-11-21	36
6	AC	Cost/Part: 34.01	SUC	05-11-22	36
7	DC	Close W/O 36.25 Inspect Level 21	LD	05/11/22	36

Rev	Date	Change	Revised By	Approved
A	97.12.03		BW	
B	98.09.09	Bending now in-house	KS	
C	99.06.04	Re-format, Added cut	DM	
D	02.07.26	Change Dwg to rev.B; Updated Location	RF	

**RELEASED**  
02/08/15 RF

4600-1-160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

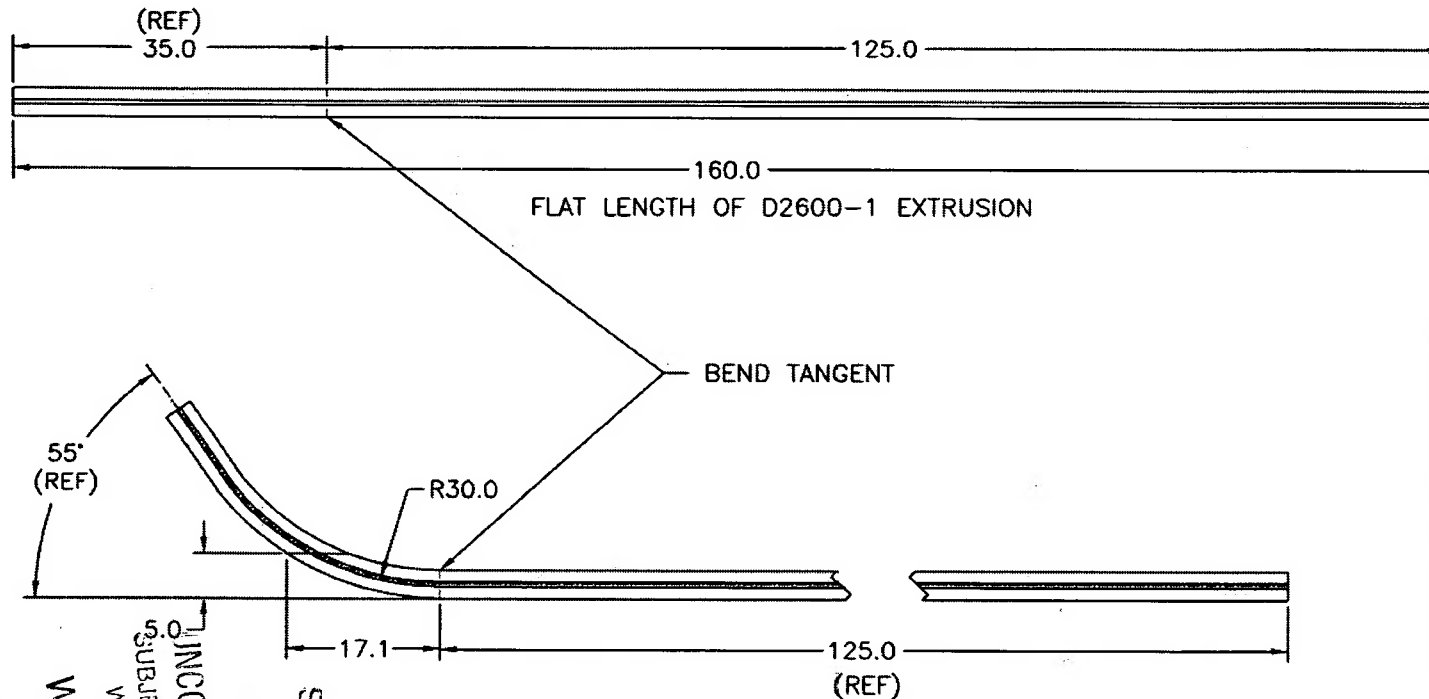
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 05/11/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**DART**



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	DATE	TITLE
99.09.10	97.11.07	206 SKIDTUBE BENDING CONTROL
A	B	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
REV. B	SCALE	SHEET 1 OF 1
1:20		

**RELEASED**  
49.04.15 DS

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 11, 2005  
07:41 am

Work Order No : 0024497  
Project Name : D2620  
Project For : WK544  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2620  
Description : Bent 206 Skidtube  
Manufactured : Yes  
Amount Req'd : 30  
Amount Done : 0  
Start Date : 10-08-05  
Est Finish Date : 11-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:20 pm

Work Order No : 0024497  
Project Name : D2620  
Project For : WK544  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2620  
Description : Bent 206 Skidtube  
Manufactured : Yes  
Amount Req'd : 30  
Amount Done : 0  
Start Date : 10-08-05  
Est Finish Date : 11-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.75	100.00		
Production Cost :	0.00	15.20	100.00	0.00	15.20
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	15.20	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	15.20			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -15.20)

MIS 0/B  
u  
11.13



Date: Monday, 14/11/2005 8:28:13 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206 EXTRUSION BENDING
<b>Job Number</b>	: 24497		
<b>Estimate Number</b>	: 10311		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2620
<b>This Issue</b>	: 14/11/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2620 REV B
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	:	<b>Drawing Revision</b>	: B
	<b>Type</b> : LANDING GEAR	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/11/2005
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	30 Um: Each
<b>Comment</b>	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D26001	Extrusion Round 3" 206
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2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A  
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock  
 Location: \_\_\_\_\_

5.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion

